

Date: Wednesday, 1/23/2008 11:39:13 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	DOUBLER		
Job Number	36929			Part Number	D2912		
Estimate Number	11593			Drawing Number	D2912 REV A		
P.O. Number				Project Number	N/A		
This Issue	1/23/2008	S.O. No.		Drawing Revision	A		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	SMALL /MED FAB	Due Date	1/30/2008	Qty:	40
Previous Run	31829			Um:	Each		
Written By	<u>HB</u> 08 01 23						
Checked & Approved By							
Comment	Est B 02.11.12 Re-format; Incorporated D2911 and D2912 K J Est Rev:C Now on Waterjet 07-01-23 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S090	6061-T6 .090 Sheet
 <b>Comment:</b> Qty.: 0.1030 sf(s)/Unit Total : 4.1202 sf(s) 6061-T6 .090 Sheet Material: Sheet 6061-T6 x 0.090" thick (M6061T6S.090) Batch: <u>19295</u> HB 8-1-25		
2.0	WATER JET	FLOW WATER JET
 <b>Comment:</b> FLOW WATER JET 1-Cut as per Dwg D2912 Dwg Rev: <u>A</u> HB 8-1-25 Prog Rev: <u>A</u> <span style="border: 1px solid black; border-radius: 50%; padding: 5px; display: inline-block;">41</span>		
2-Deburr if necessary HB 8-1-25		

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
<b>Comment:</b> SECOND CHECK		

✓ 08/01/25 +41 counts

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08/02/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: DOUBLER
Job Number: 36929		Part Number: D2912
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	BRAKE NC	NC BRAKE 
Comment: NC BRAKE Form on CNC brake as per Dwg D2910, D2911, D2912 and QSI 034 4.1		SB 08/01/08 41
6.0	CHEMICAL TREAT	CHEMICAL TREATMENT 
Comment: CHEMICAL TREATMENT		MH 08/02/08
7.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		08/02/08 41
8.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: STS3		A8 08/02/08 41
9.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		H 08/02/08
Job Completion		 in 2008/2/07 41 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36929
Description: Doubler	Part Number:	D2912
Inspection Dwg: D2912 Rev: A		Page 1 of 1

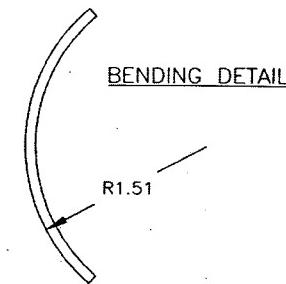
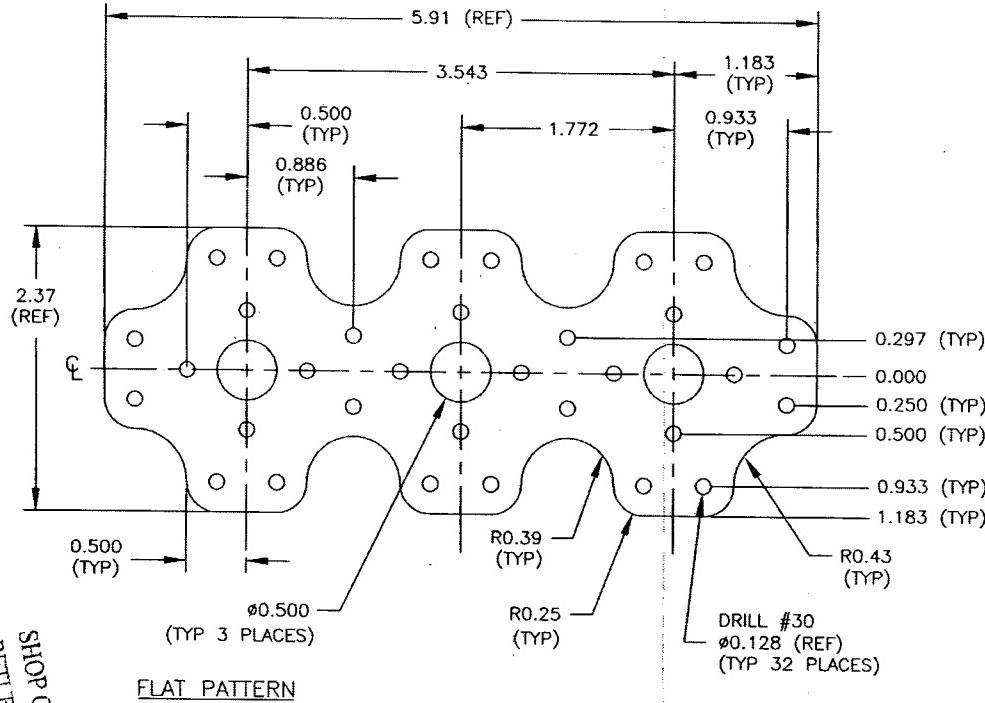
# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	B	Audited by:		Prototype Approval:	N/A
Date:	8-1-25	Date:	08/01/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM <i>[Signature]</i>	<i>BZ</i>

RELEASED  
99.09.28 DS



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO.  
36921

MATERIAL: 6061-T6 SHEET (QQ-A-250/11) 0.091" THICK  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

A	99.09.07	NEW ISSUE
DESIGN	CP	DRAWN BY RF
CHECKED	CP	APPROVED
DATE	99.09.07	TITLE DOUBLER
		DART AEROSPACE USA, INC. BELLEVUE, WA
		DRAWING NO. D2912
		SHEET 1 OF 1
		SCALE 1:1